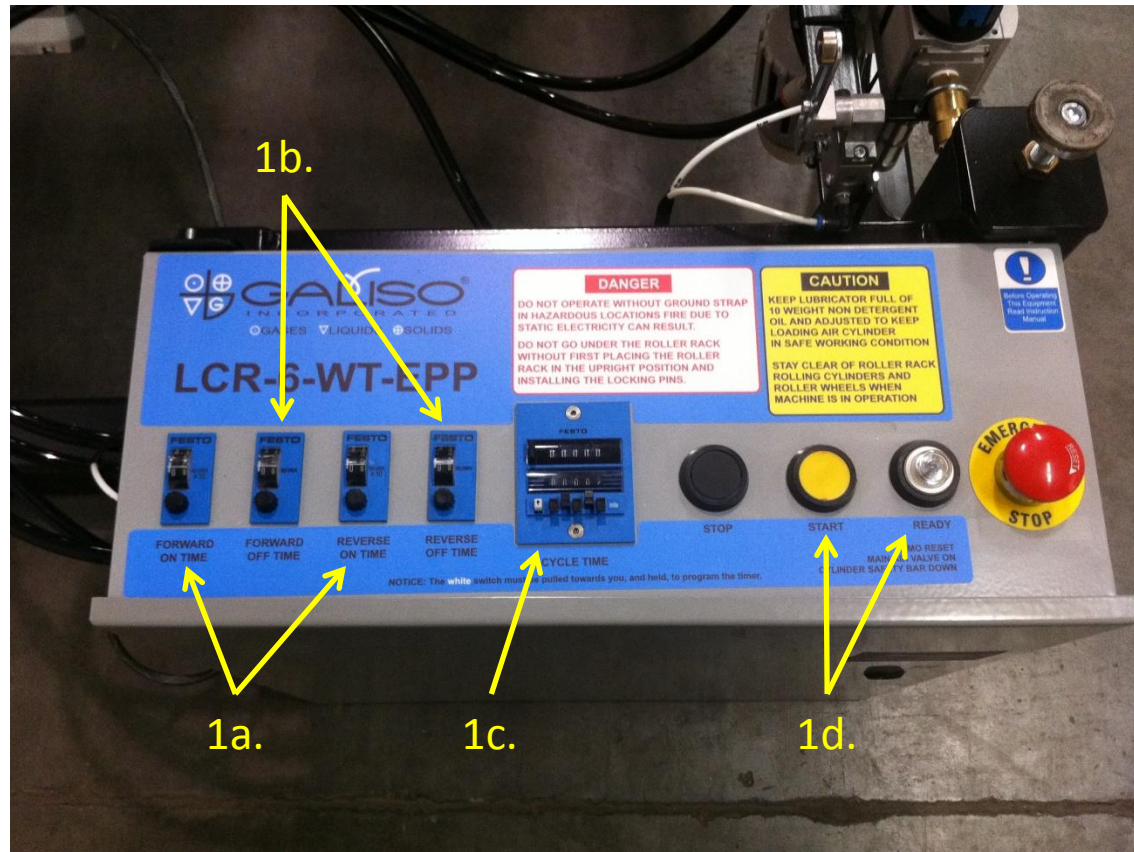


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Pneumatic control troubleshooting step 1



1a. Set Forward/Reverse on time to 20 seconds

1b. Set Forward/Reverse off time to 2 seconds

1c. Set Cycle time to 2 minutes

1d. Verify that the yellow ready light is on and press the yellow start button

1e. Verify that roller rack lowers and when rack is down that rollers begin to roll in both directions and that the roller rack goes back up after the 2 minute cycle completes

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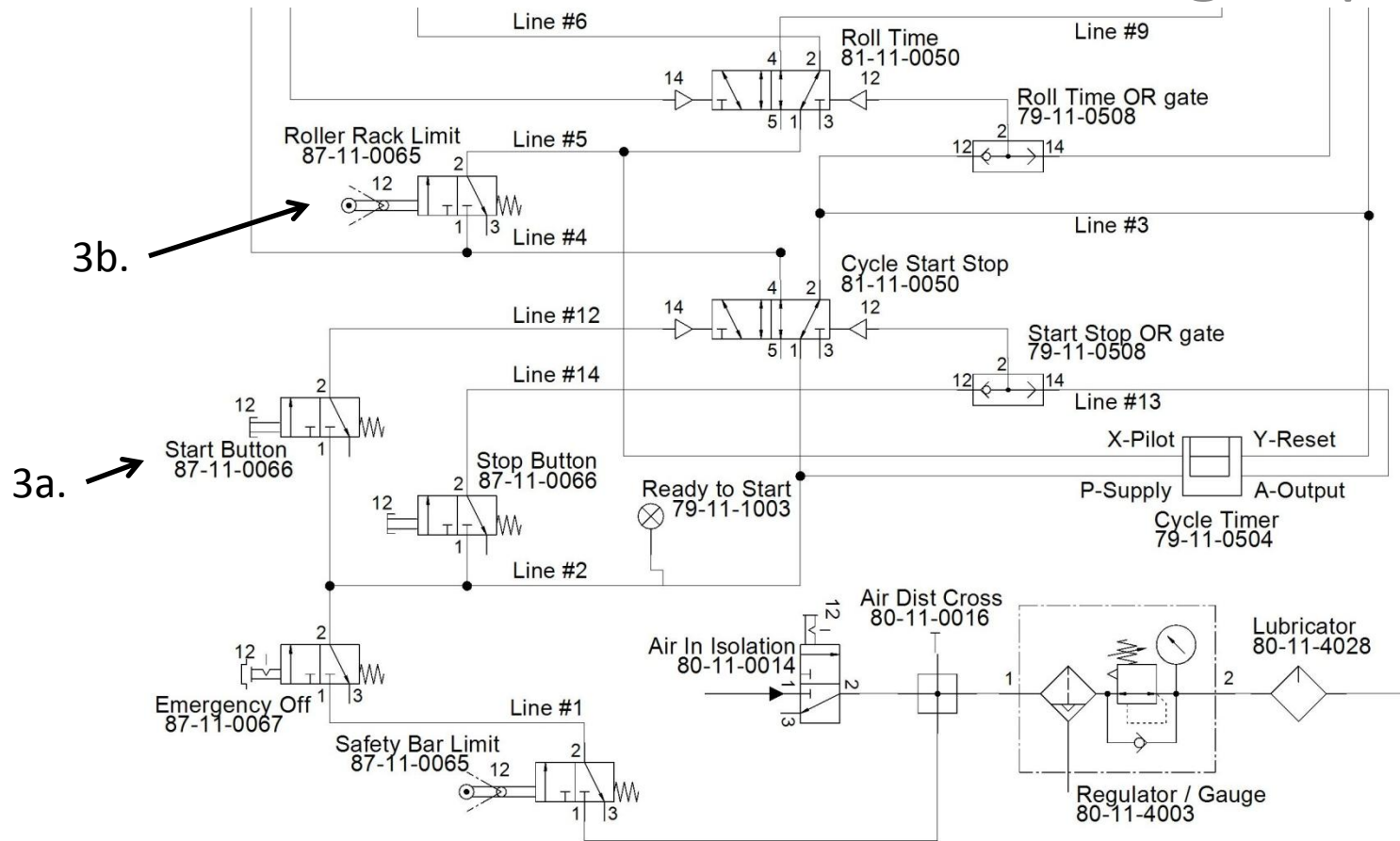
Pneumatic control troubleshooting step 2



2a. Cycle Start Stop 5 way valve 2b. Roll Time 5 way valve 2c. Roll Direction 5 way valve

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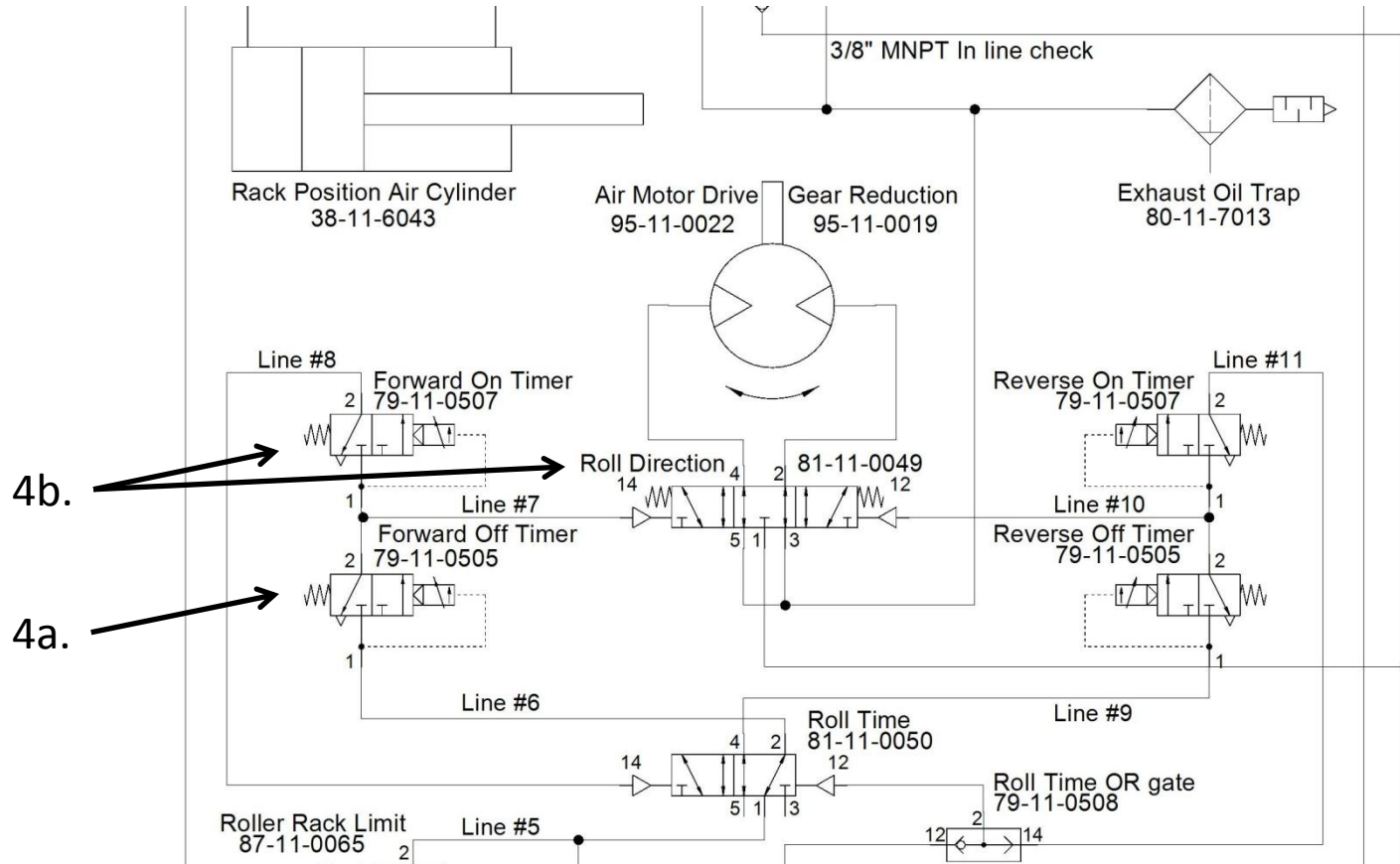
Pneumatic control troubleshooting step 3



- 3a. When the Start Button is pressed a momentary air signal is sent to Line #12 that changes the continuous air output from the Cycle Start Stop from Line #3 (Stop) to Line #4 (Start)
- 3b. When the Roller Rack Limit switch is pushed in by the Roller Rack a continuous air signal is sent to Line #5 which provides supply air to the Roll Time 5 way valve circuit and a Pilot signal to port X that starts the Cycle timer

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Pneumatic control troubleshooting step 4

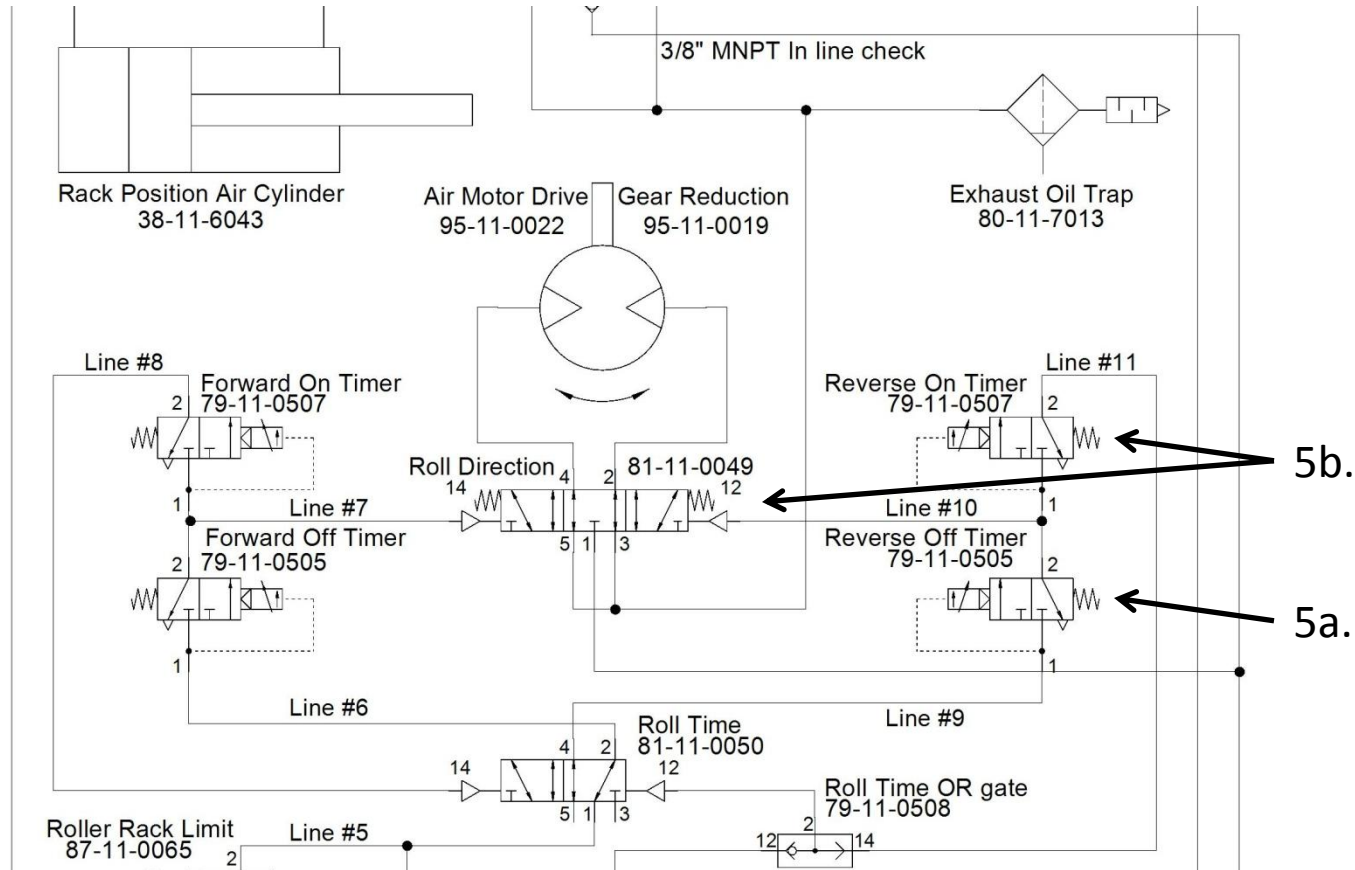


4a. When air is supplied to the Roll Time 5 way valve it is first sent to Line 6 which starts the Forward Off Timer.

4b. At the end of the 2 second Forward Off Time, air is sent to Line #7 which is connected to both the Roll Direction 5 way valve and the Forward on timer. This runs the Air Motor Drive in the Forward direction for the 20 second Forward on time.

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Pneumatic control troubleshooting step 5

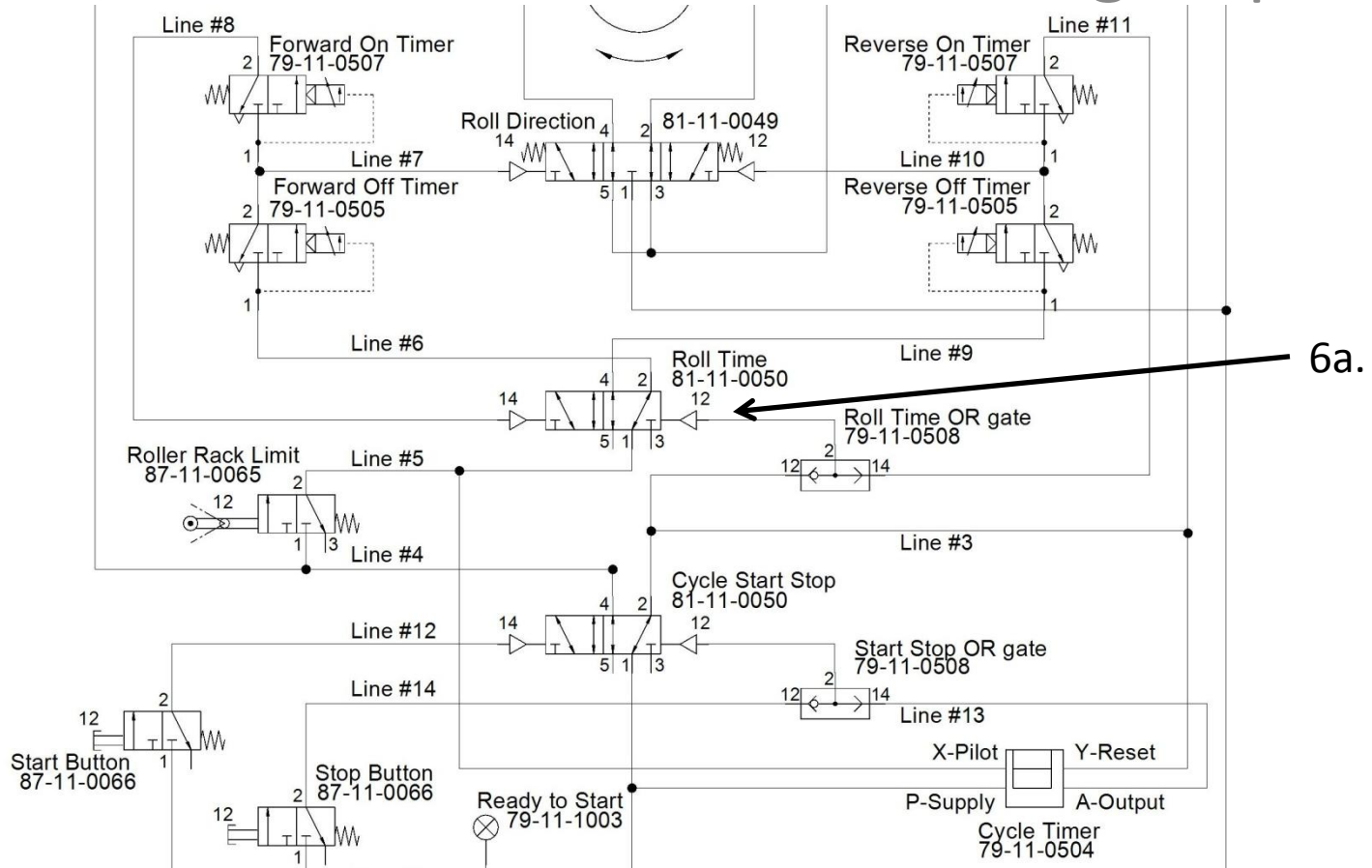


5a. At the end of the Forward time, air is sent on Line #8 to port 14 of the Roll Time 5 way valve which changes the valve position to send air from the supply port to Line #9 which starts the Reverse Off Timer time of 2 seconds.

5b. At the end of the 2 second Reverse Off Time, air is sent to Line #10 which is connected to both the Roll Direction 5 way valve and the Reverse on timer. This runs the Air Motor Drive in the Reverse direction for the 20 second Reverse on time.

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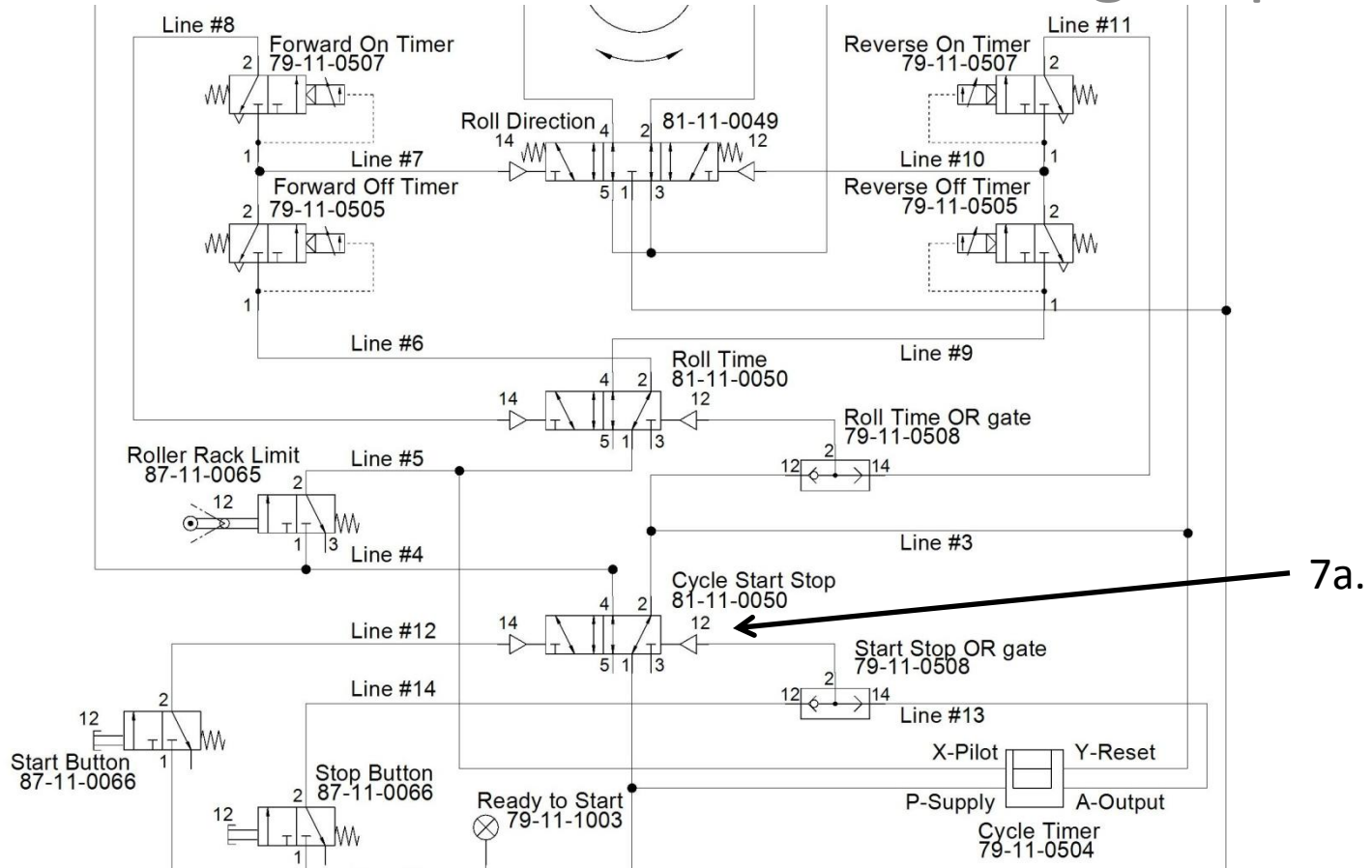
Pneumatic control troubleshooting step 6



6a. At the end of the Reverse On time, air is sent on Line #11 through the Roll time OR gate to port 12 of the Roll Time 5 way valve which changes the valve position to send air from the supply port to Line #6 which again starts the Forward Off Timer time of 2 seconds and then the Forward On Timer for 20 seconds. Cylinder rolling in both directions continues in this manner until the Cycle time of 2 minutes is complete or the Stop Button is pressed

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Pneumatic control troubleshooting step 7



7a. At the end of the Cycle time of 2 minutes or when the Stop Button is pressed an air signal is sent through the Start Stop OR gate to port 12 of the Cycle Start Stop 5 way valve. This air signal changes the Cycle Start Stop valves air output from Line #4 back to Line #3 which stops the cylinder rolling process and returns the cylinder Roller Rack to the upright position